

FIG.1

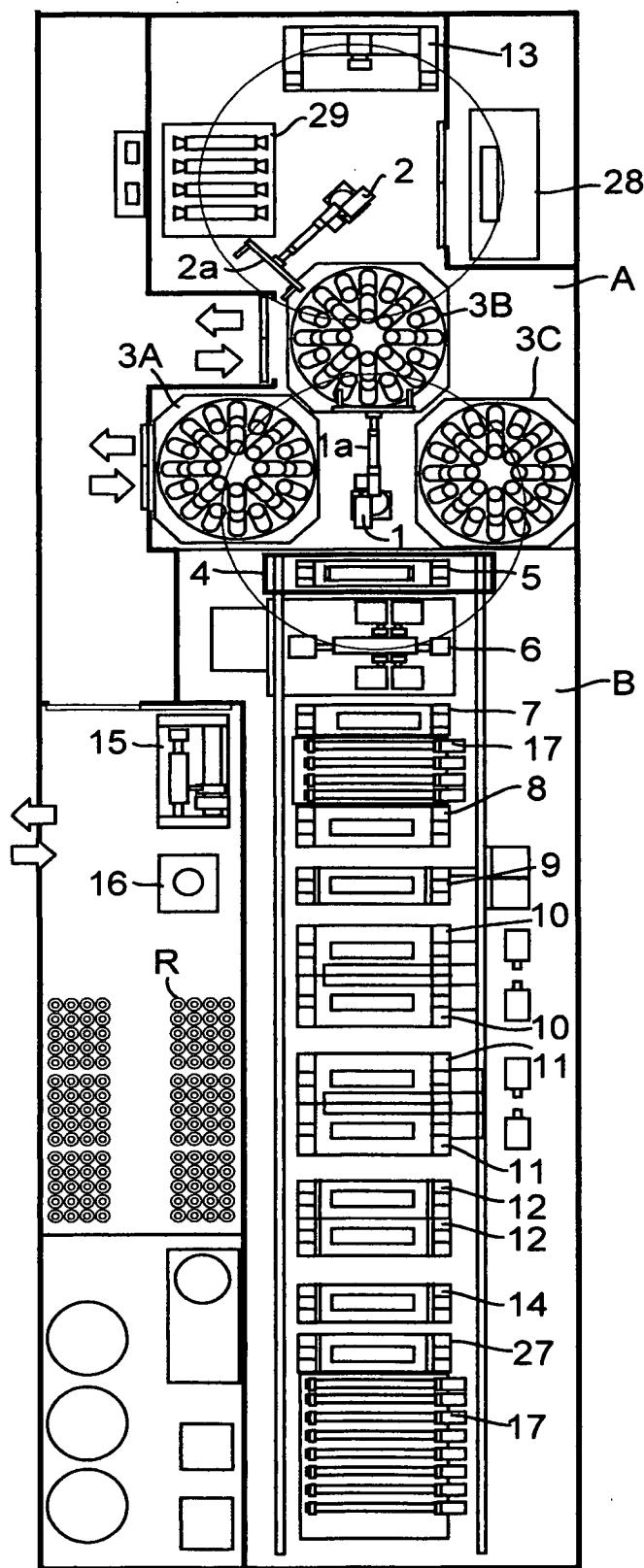


FIG.2

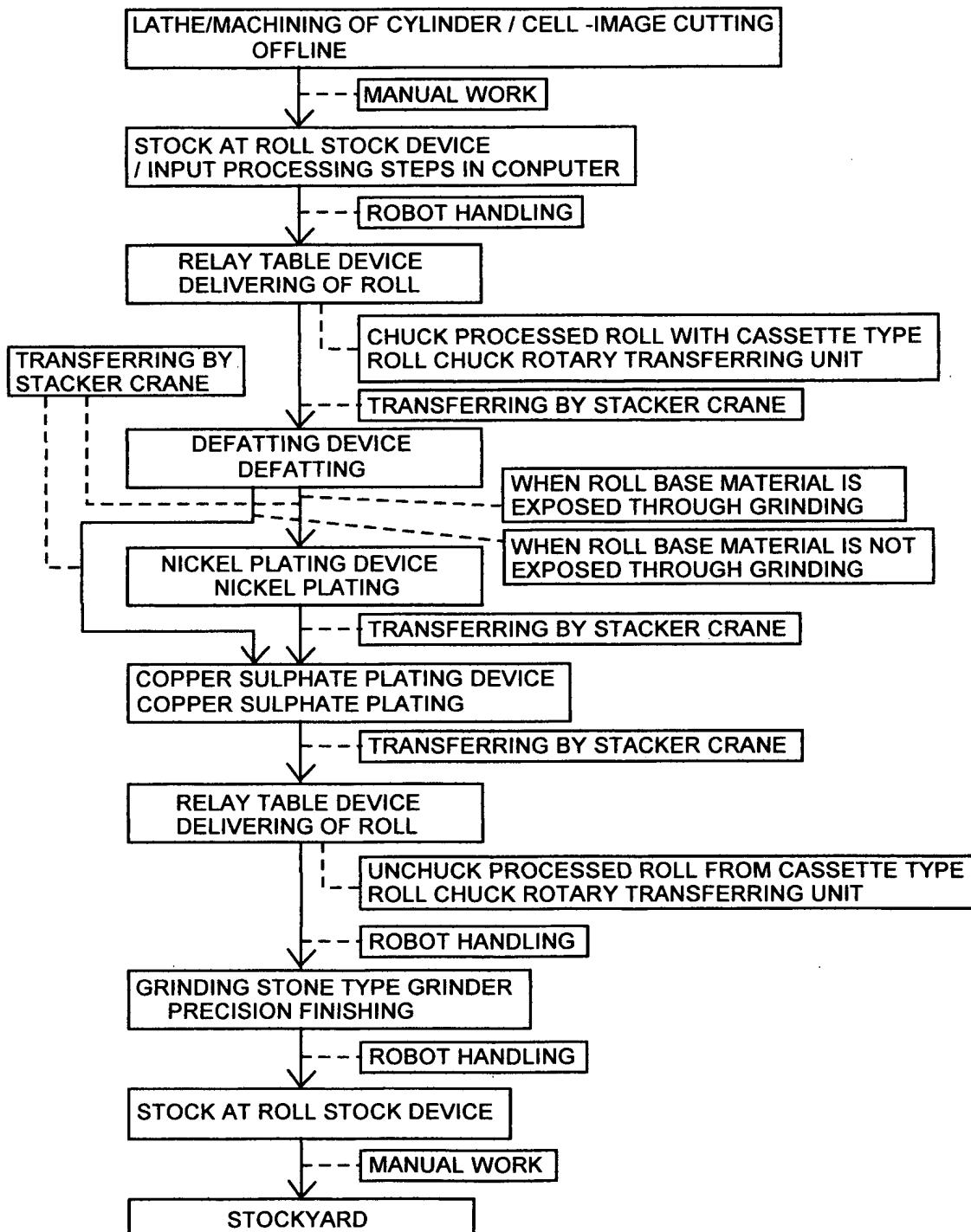


FIG.3

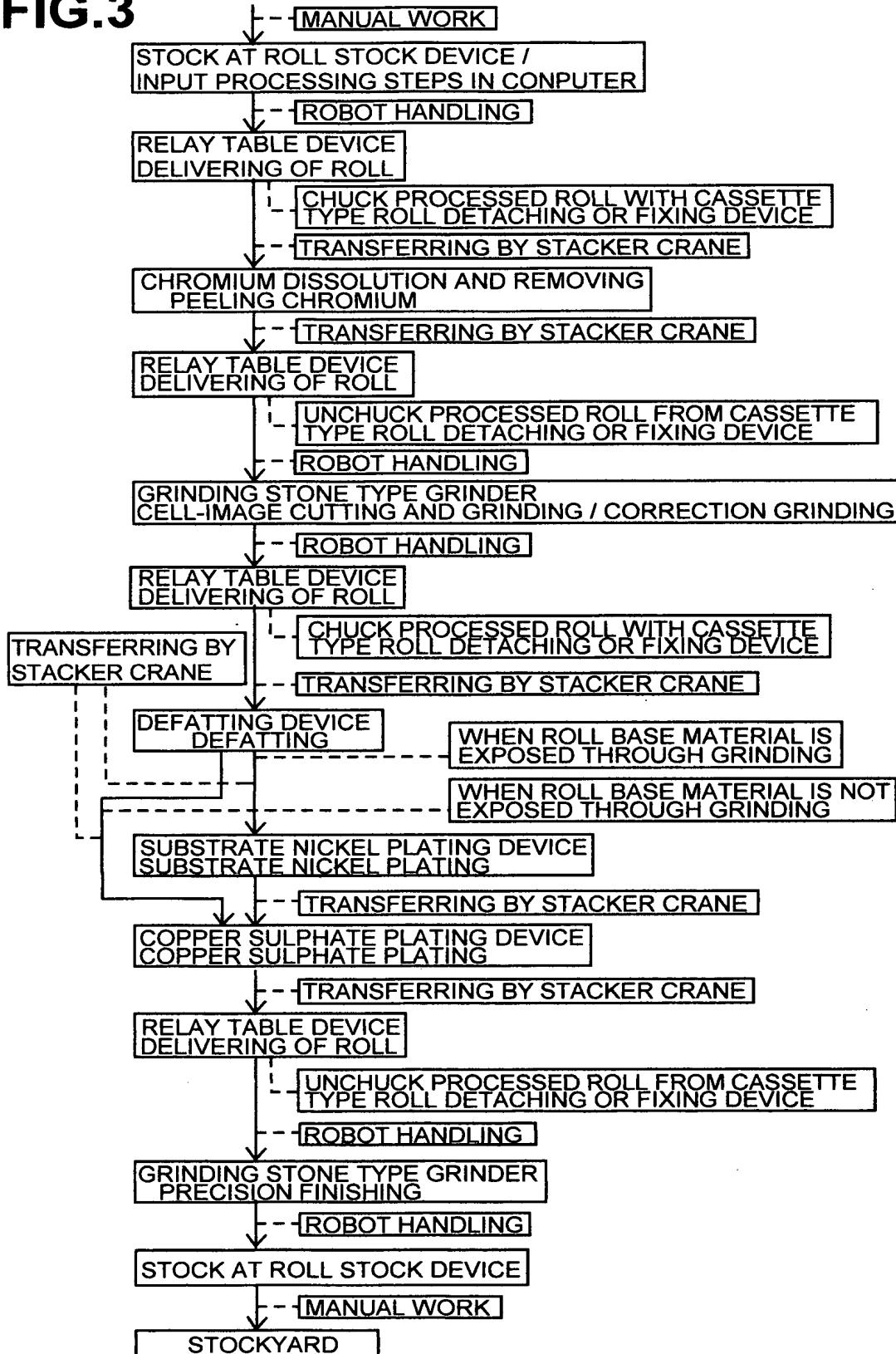


FIG.4

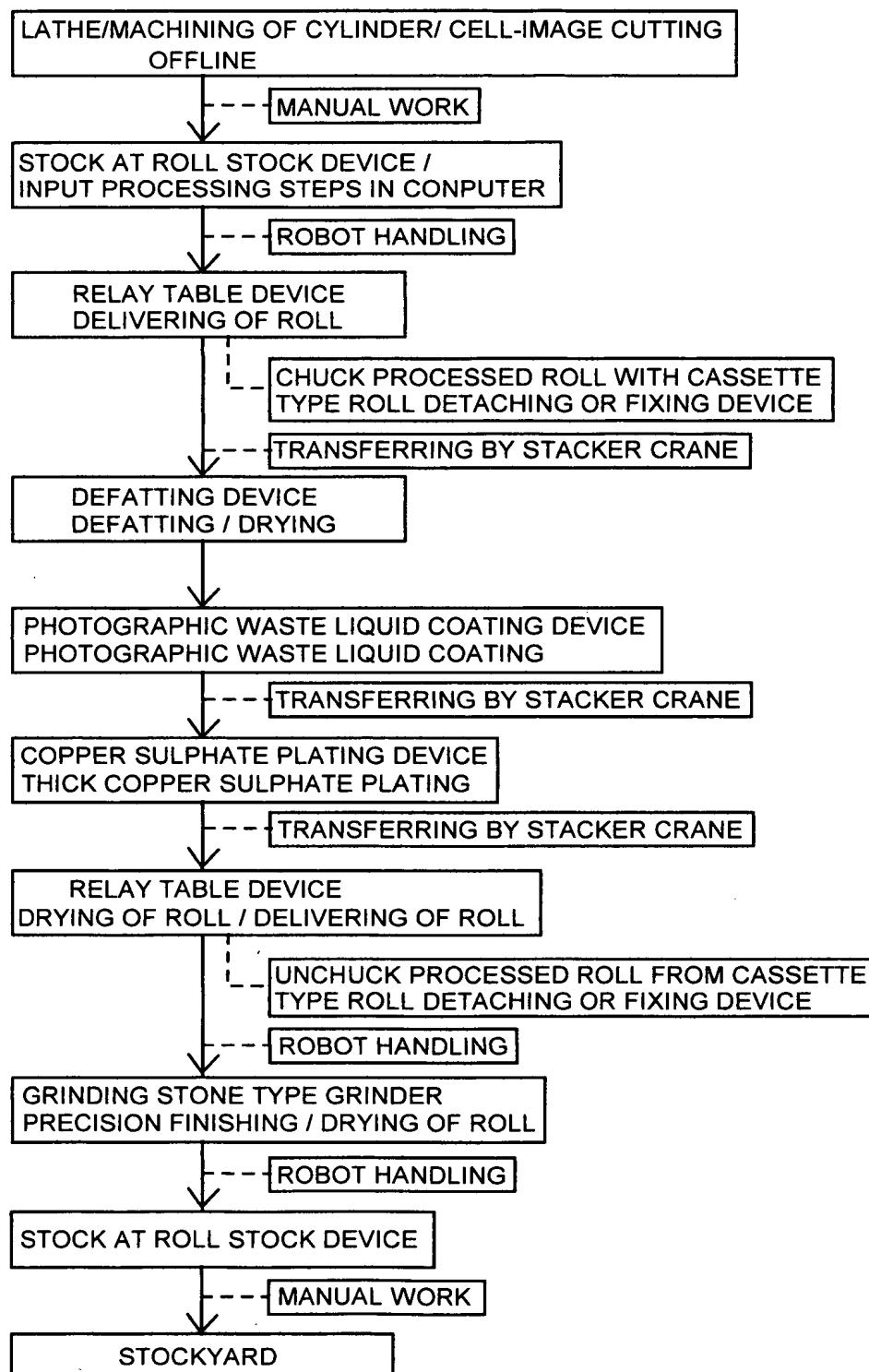


FIG.5

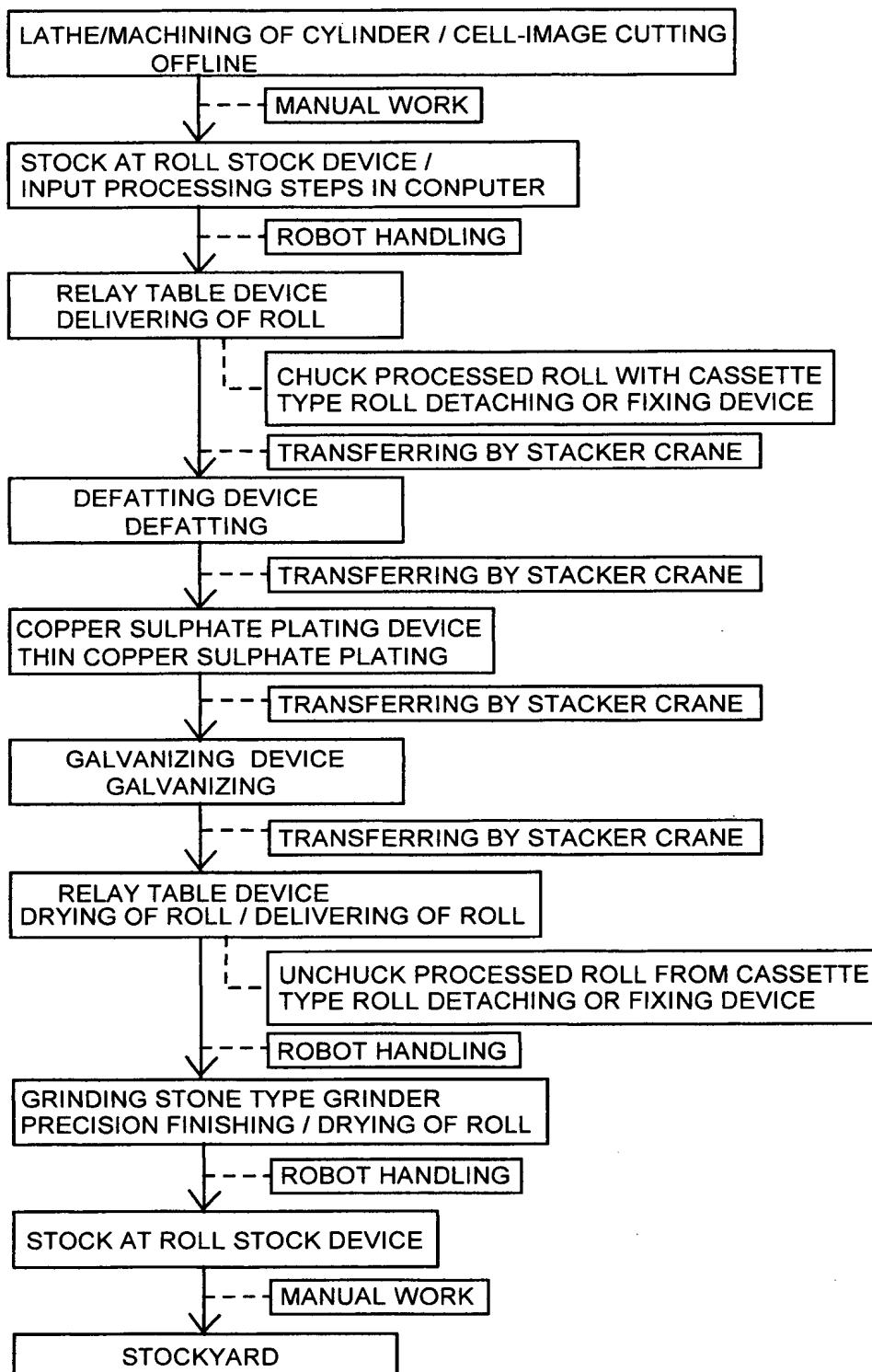


FIG.6

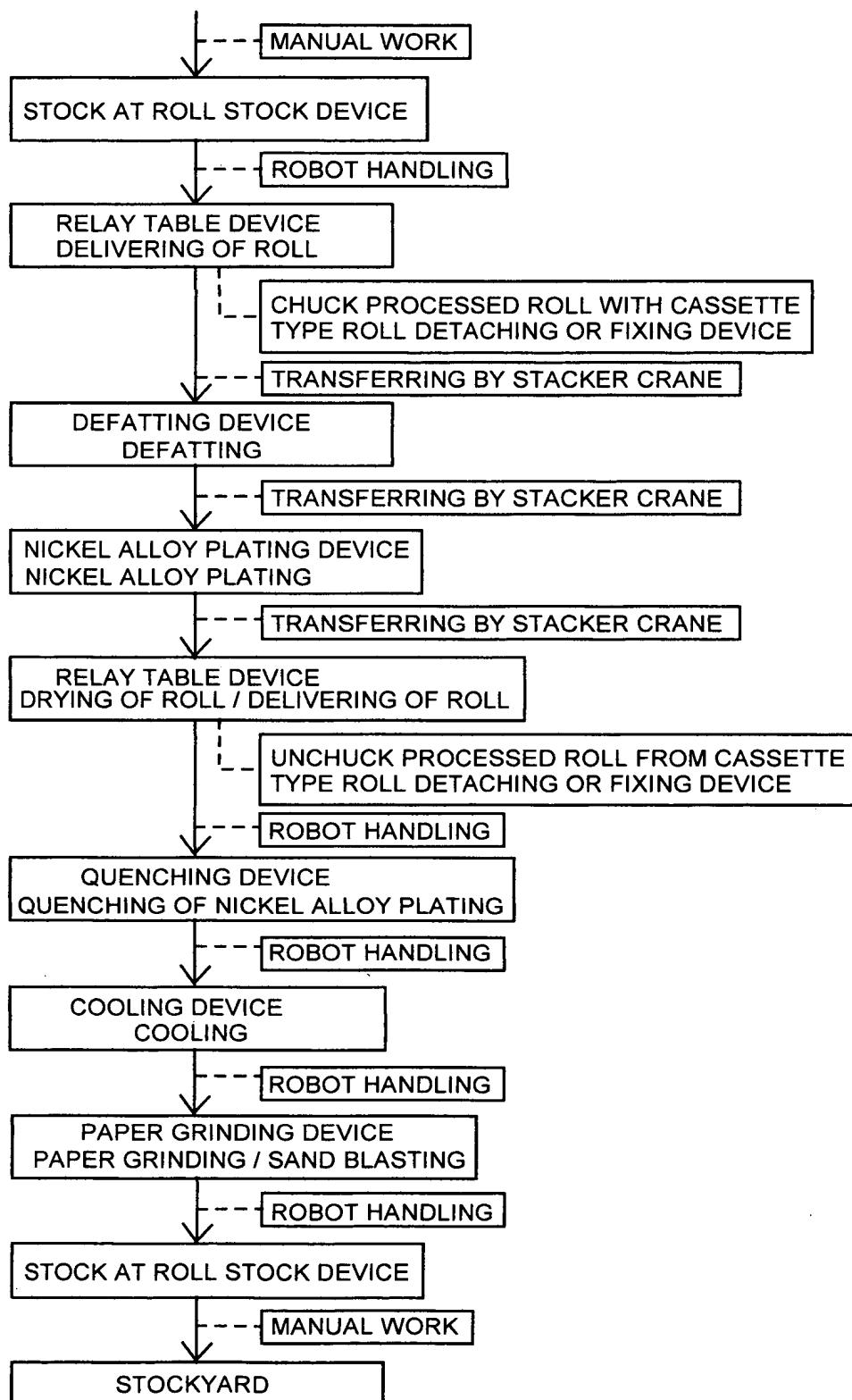


FIG.7

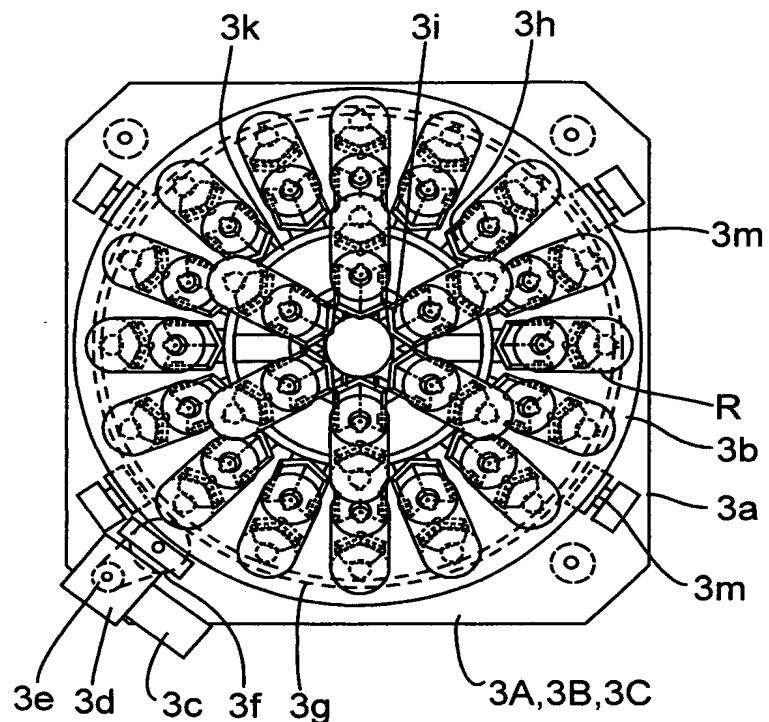


FIG.8

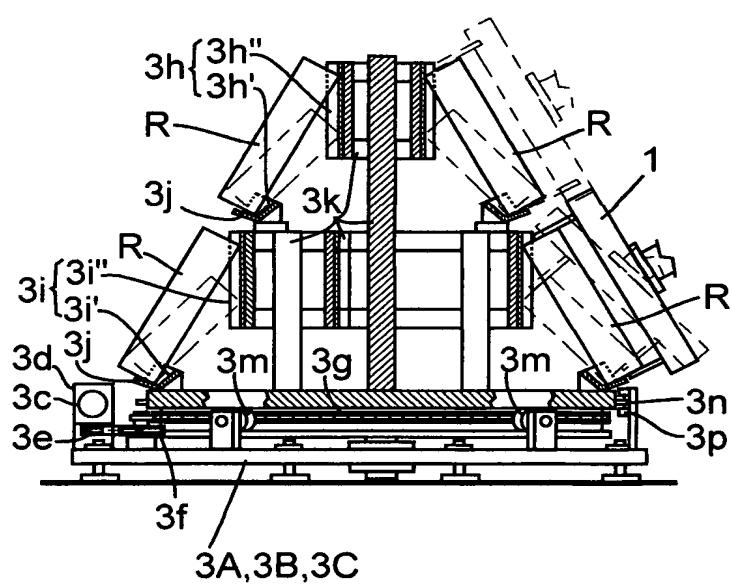


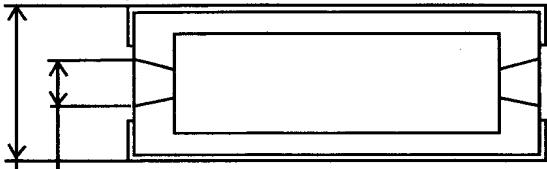
FIG.9

Data Input Sheet

Roll Identification No.

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Roll Length = mm



Chuck Hole Diameter = mm

Roll Diameter = mm

Chromium Plating Thickness = 8 μm

Copper Sulphate Plating Thickness = 130 μm

Nickel Plating Thickness = 2 μm

Minimum Cutting Margin = 48 μm

Allowable Eccentric Amount = 30 μm

Minimum Allowable Copper Sulphate Plating Thickness After Cylindrical Machining = 20 μm

Copper Sulphate Plating Thickness Left on Machined End Surface = 160 μm

Measurement Run

Set

Chuck Automatic

Automatic transmission of Measurement

Automatic transmission of Machining

Measurement Run

Set

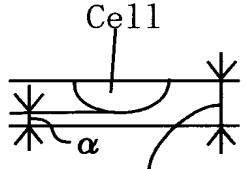


FIG.12

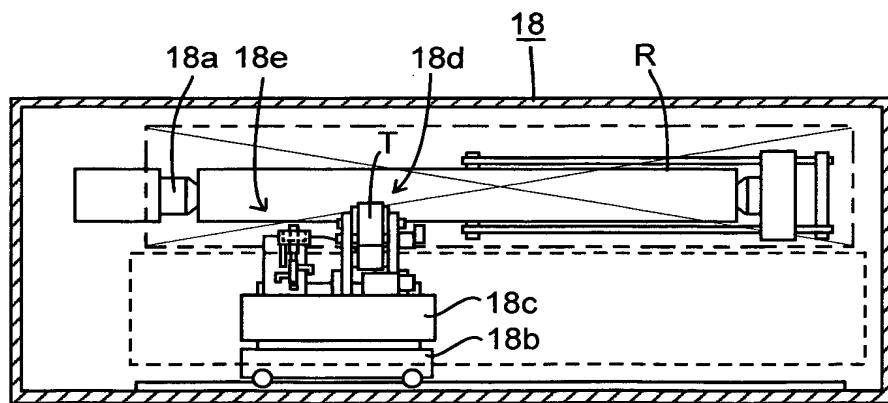


FIG.10

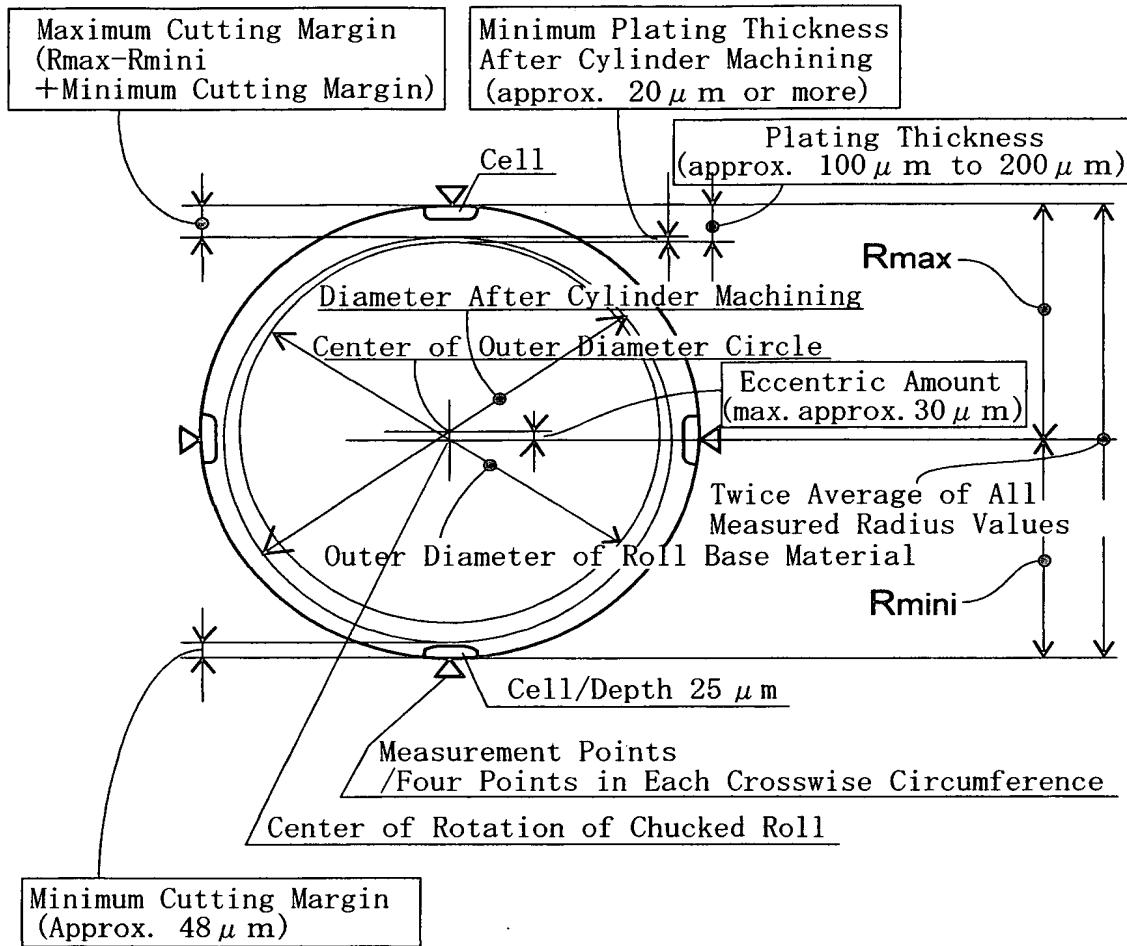


FIG.11

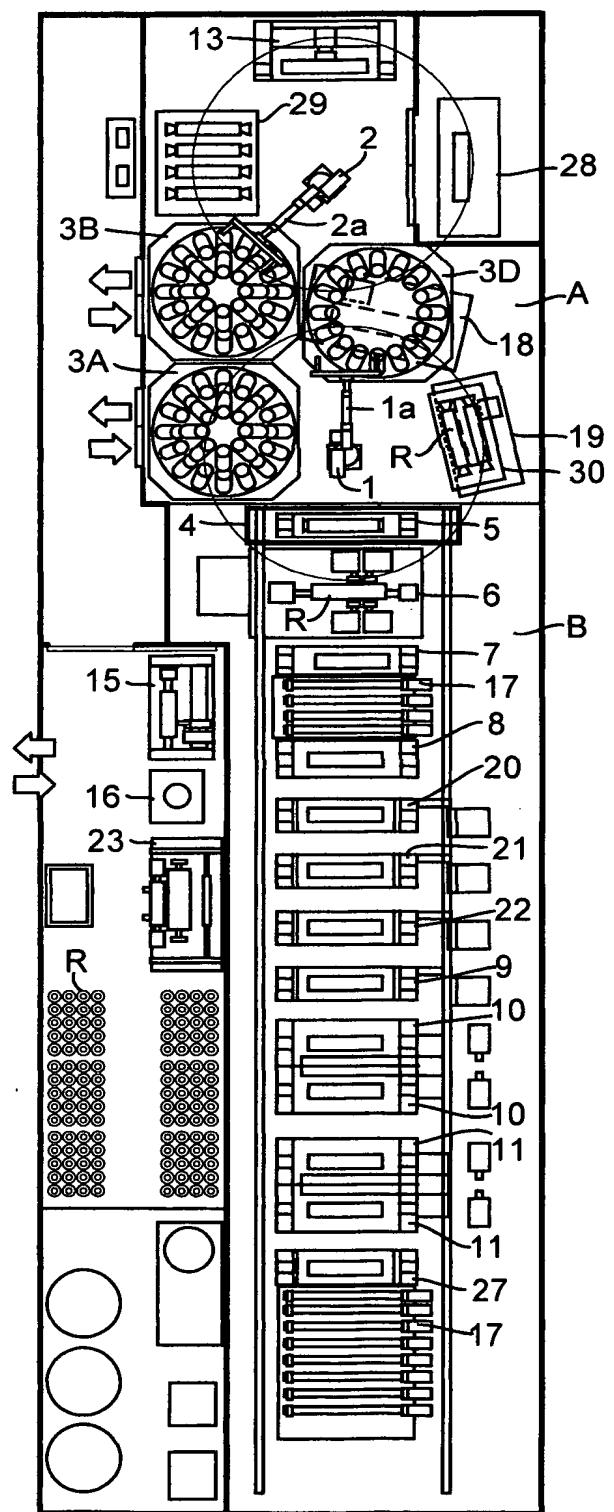


FIG.13

